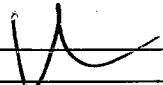
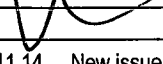


Sept. 1

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 7:19:57 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT WELDMENT ASS'Y
Job Number : 28187	
Estimate Number : 10569	
P.O. Number : N/A	Part Number : D34437
This Issue : 15/08/2006 S.O. No. : N/A	Drawing Number : D3443 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 27797	Material : N/A
Written By : 	Due Date : 31/08/2006 Qty: 10 Um: Each
Checked & Approved By : 	
Comment : A 05.11.14 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TR0750W120	Inventory
-----	----------------	-----------



Comment: Qty.: 0.7875 f(s)/Unit Total: 7.8750 f(s)

AISI 304 SS seamless tubing 0.750" OD x 0.120" wall
(M304TR0750W120)

Batch: M 101580 *9 / B 18457 *1

FF 06.08.17 10

2.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1- Form as per Dwg D3443 using DT8117

2- Deburr per dwg D3443

SP 06/08/24 (10)

SA FF 06.08.24 10

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

06.08.28 (10)

4.0	MILLING CONV.	CONVENTIONAL-MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

1- Mill end to length and drill hole as per dwg D3443

2-Deburr as per dwg D3443

06/09/06 10

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/09/06 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *SE* Date: 06/09/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:19:57 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 28187

Part Number: D34437

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 06.09.06

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

PD 06-09-09 (10)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/11

Job Completion



W 06-09-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

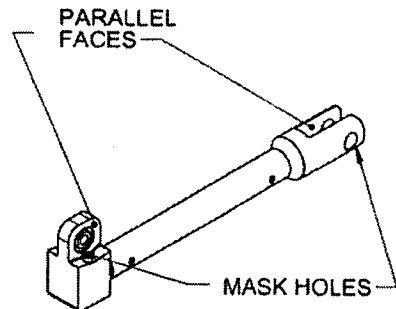
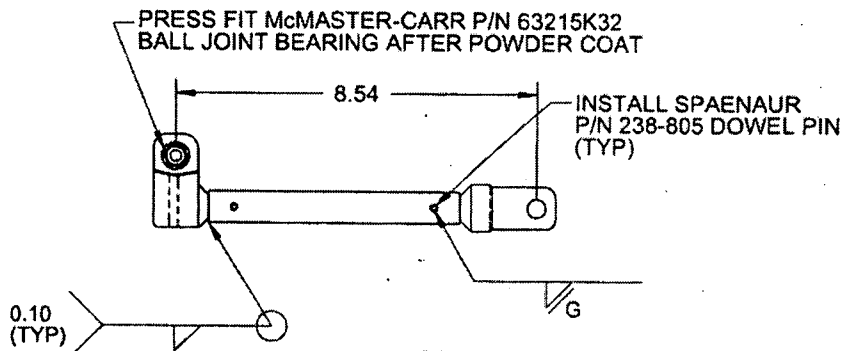
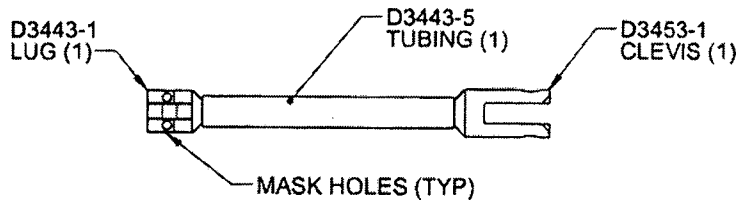
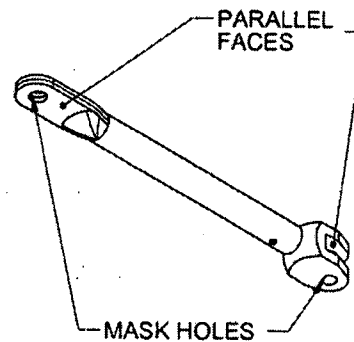
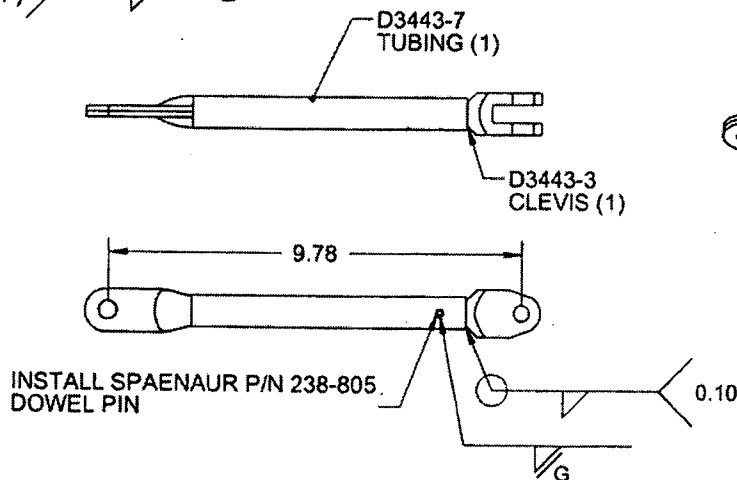
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:4
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	

RELEASED

05-12-09 #

**D3443-041****REFERENCE ONLY****D3443-043****NOTES:**

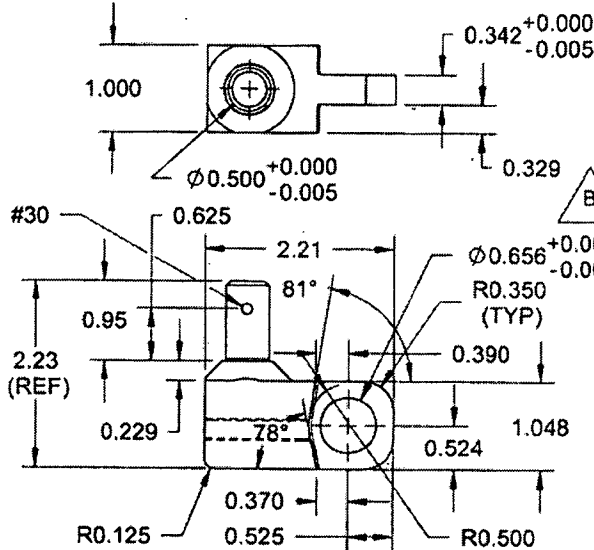
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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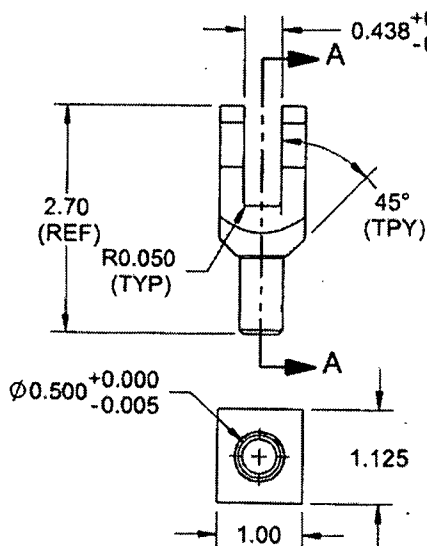
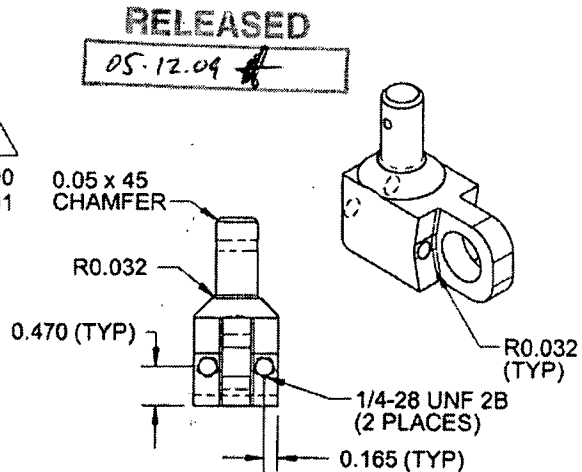
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:2

**D3443-1 NOTES:**

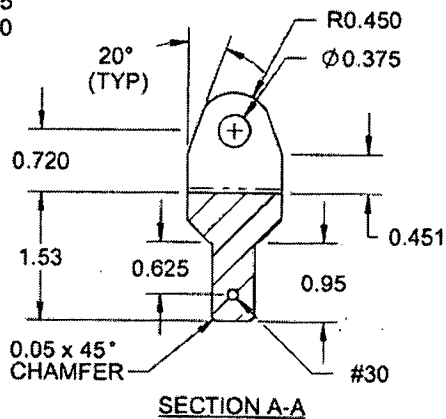
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

D3443-1 LUG**D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

**D3443-3 CLEVIS**

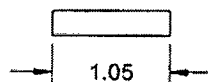
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:2

$\phi 0.210^{+0.005}_{-0.010}$



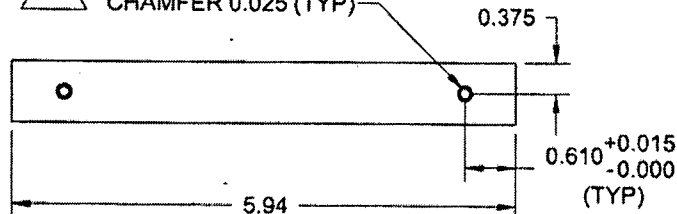
D3443-9 PIN

D3443-9 NOTES:

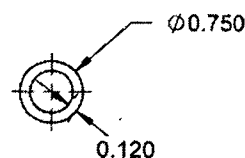
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)

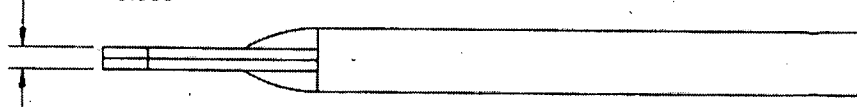


RELEASED
05.12.09



D3443-5 TUBING

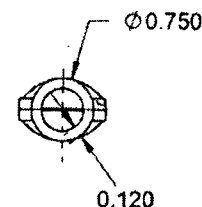
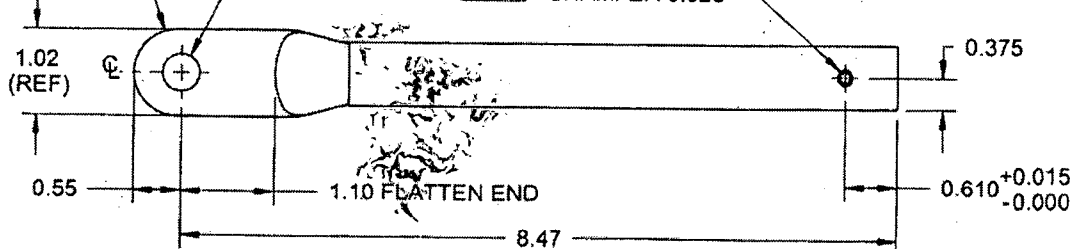
$0.260^{+0.000}_{-0.030}$



R0.51
 $\phi 0.438$



DRILL $\phi 0.125$ THRU
CHAMFER 0.025



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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